

Work Order ID 62176

Monday, September 20, 2010 10:27:20 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 9/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10/9/20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A Ch 10/11/03

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

CNC Delta 100 Bender

Memo

0.00

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

DP 10-9-27

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



HandFinish

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
 A/R Sikaflex-291 11/18/14
 Sikaflex expire date: 11/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
 A/R Sikaflex-291 11/14/14
 Sikaflex expire date: 11/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
 Batch: 1111028

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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

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Work Order ID: 62176



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 9/20/2010

Required Date: 10/4/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

NAS1149C0332

R

Purchased

No

200

Each

29.0000

50

50

washer

D3566-13



Manufactured

No

Location

ST245

Loc Qty

29

Loc Code

M115816

X50

Gasket

D3566-5



Gasket

Manufactured

No

Location

FP012

Loc Qty

14

Loc Code

V1

59661
60209

6

8

200

Each

15.0000

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

D3566-1



Gasket

Manufactured

No

Location

FP

Loc Qty

15

Loc Code

V1

60869

15

200

Each

20.0000

2

2

2

2

2

2

2

2

2

2

2

2

2

2

2

2

2

2

2

W/O:		WORK ORDER CHANGES					
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Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 9/20/2010

Required Date: 10/4/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-11



Wearshoe

Manufactured No

200

Each

7.0000

1

1

41 10110106

D3564-13



Wearshoe

Manufactured No

200

Each

13.0000

1

1

41 10110106

D3564-9



Wearshoe

Manufactured No

200

Each

11.0000

1

1

41 10110106

Location

Loc Qty

Loc Code

FP019

7

60302

7

Location

Loc Qty

Loc Code

FP17

13

59660

1

60862

12

Location

Loc Qty

Loc Code

FP

1

55334

1

FP019

10

60236

10

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Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 9/20/2010

Required Date: 10/4/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5



Manufactured No

200

Each

15.0000

1

1

Wearshoe



gl 1610106

D2594-3



Manufactured No

200

Each

1,083.000

16



gl 1610106

O-Ring, 205 Skidtube

Location	Loc Qty	Loc Code
----------	---------	----------

FG	1	
34806	1	
FP19	8	
57525	1	
58709	1	
61699	6	
FP-19	6	
<u>60868</u>	6	

Location	Loc Qty	Loc Code
----------	---------	----------

FP	83	
55546	19	
58191	12	
59358	52	
fpa	1000	
<u>61762</u>	1000	

Location	Loc Qty	Loc Code
----------	---------	----------

FP	183	
42807	112	
55002	71	
FP14	44	
58434	15	
59110	29	

D2594-1



Manufactured No

200

Each

227.0000

16



gl 1610106

Plug, 205 Skidtube

Location	Loc Qty	Loc Code
----------	---------	----------

FP	183	061932
42807	112	
55002	71	
FP14	44	
58434	15	
59110	29	

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DESIGN 11	DRAWN BY BB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED 11	APPROVED BB	DRAWING NO. D2580	REV. D	SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS	
A	96.09.16	NEW ISSUE		
B	96.12.02	AS MANUFACTURED		
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097		
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183		

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AEIS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
 - SEE NOTES ON
 - PAGE 2 FOR D2580-041 AND
 - PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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NO. 238

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 61352
Part number: D205-634.041
Description: 205 skid tube
Welding Process: Tig[] Mig[]
Base materiel: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[] fail[]
Penetration: pass[] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]
Undercut: pass[] fail[]
Pin holes: pass[] fail[]
Overlap (cold lap) pass[] fail[]
Porosity (surface): pass[] fail[]
Coloration: pass[] fail[]

Qualifier Barclay Elliott Date of Test Coupon 10.08.25

Welder Barclay Elliott Date of Test Coupon 10.08.25

The above named individual is qualified in accordance with AWS D17.1.2001 to weld